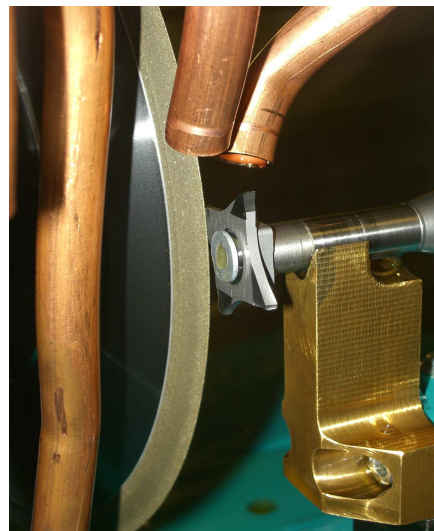









Turning Profile Insert

A08-350

The on edge profiled insert is ground totally in one setup using the TTC-clamping system. The operations include pregrinding and finishing of the profile as well as the chipbreaker, optionally the reference faces can be included. Quinto automatically considers the distortions given by the turning parameters, chipbreaker- and holderangles.



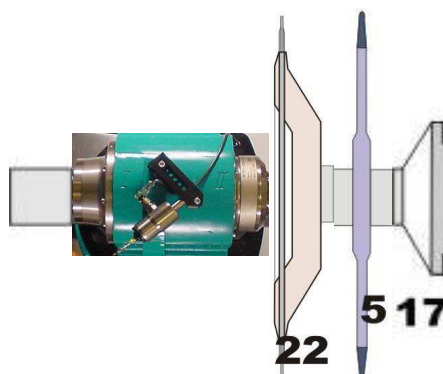
1. Cycletime for Production

Tool specifications				
Semitriangle 32x22x5.7				
Material CARBIDE				
Operations				
Feed [mm/Min]	2000	30	45	10
Power [kW]		1	1	1
Cutting feed [m/s]		22	22	22
Used wheels				
Grinding time [s]	16	197	143	148
Total cycle time	8 Min 24			

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

5 Ø200 14EE1 D64
22 Ø300 14EE1 D46
17 Ø125 12A2 D64



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : CORVUS GDS, GEMINI DMR, NORMA CFG
Control: Fanuc 160i
Coolant: Synthetic Oil, pressure 6 - 7 bar
Software: Quinto 4.3, DXQ

responsible engineer: OP,13.5.08

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